

Work Order ID 66333

Thursday, February 10, 2011 10:38:47 AM



ASAP

Page 1

Item ID: D4314-3

Accept



Setup Start



Revision ID:

Item Name: Shim

Stop



Start Date: 2/10/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

mf

Date: 11-02-10

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4314

A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4314

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B 11-2-10

9

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 11-2-10

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/2/10

29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Page 2

Item ID: D4314-3

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Setup Start



Revision ID:

Item Name: Shim

Stop



Start Date: 2/10/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 Small Fab | Small Fab | 0.00 | | | | (9X) | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | COUNTER SINK AS PER DWG | | | | | | | | |
| | | | | | | | | | EM 11/02/10 |
| 150 QC | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| Quality Control | Memo | 0.00 | | | | (XS) | | | |
| 160 HandFinish | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| Hand Finishing | Memo | 0.00 | | | | | | | 9 BL 11-02-14 |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Work Order ID 66333

Thursday, February 10, 2011 10:38:47 AM



Page 3

Item ID: D4314-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Shim

Start Date: 2/10/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 170 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | | | | |
| 180 Packaging Packaging | Identify as per dwg & Stock Location: <u>137</u> Memo | 0.00 0.00 | | | | | | | |
| 190 QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |

9 9 11/02/10

11/02/14 (9)

11/02/14
mf
11-02-14

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, February 10, 2011 10:38:44 AM

Page 1

Work Order ID: 66333



Parent Item: D4314-3



Parent Item Name: Shim



Start Date: 2/10/2011

Required Date: 2/11/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 11-02-02 JLM VERIFIED BY:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|--------------|---------------|----------------|--------|
| M6061T6S.188  | | Purchased | No | | | 100 | sf | 36.7000 | 0.0194 | 0.163368 | | | |
| 6061-T6 .188 Sheet | | | | | | | | |  | | | | |

HB-2-15

Location

Loc Qty

Loc Code

MAT

36.7

110993

4.7

116604

32

110993

9

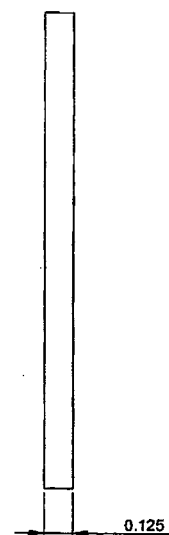
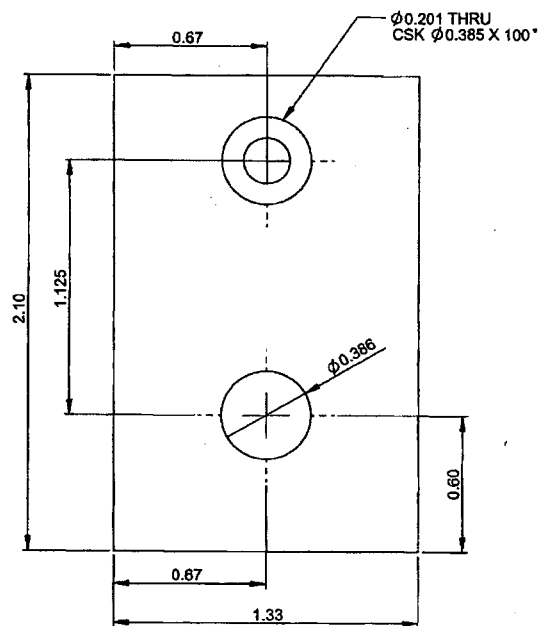
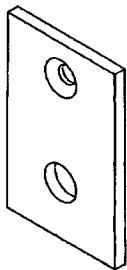
| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries



66333

D4314-1 SHIM

RELEASED
2011-02-01
MD

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.125) OR ALUMINUM 6061-T6/T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11 AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.125) OR ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A-250/8 AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

| | | | |
|--|-------------|---|--------------|
| A | NEW ISSUE | SC | 11.01.13 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | SC | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | DRAWING NO. | REV. A |
| CHECKED | | D4314 | SHEET 1 OF 2 |
| MFG. APPR. | | TITLE | SCALE |
| APPROVED | | SHIM | NTS |
| DE APPR. | | DATE 11.01.13 | |
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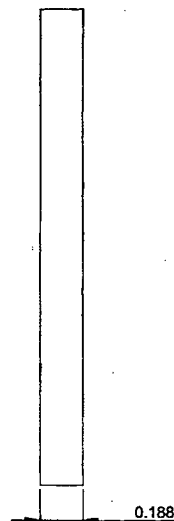
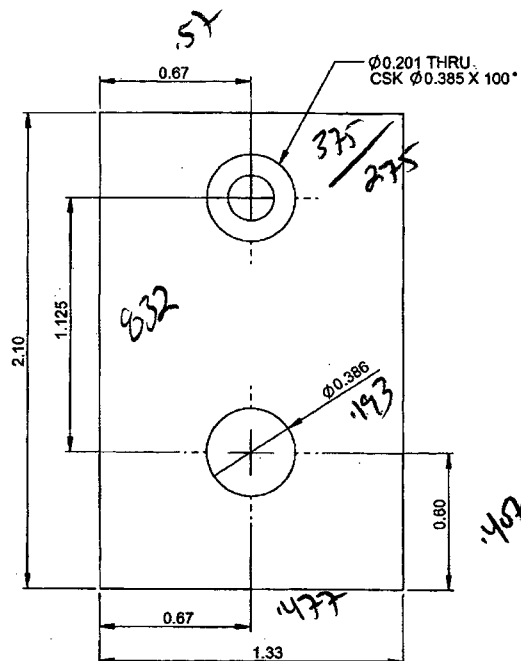
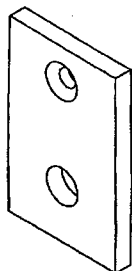
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• NOTE: Date & initial all entries



#66337

D4314-3 SHIM

RELEASED
2011-02-01
MP

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.188) OR ALUMINUM 6061-T6/T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11 AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.188) OR ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A250/8 AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.188)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

| | | | |
|--|----------|--|--------------|
| DESIGN | SC | DART AEROSPACE LTD | |
| DRAWN | SC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | MP | DRAWING NO. | REV. A |
| MFG. APPR. | MP | D4314 | SHEET 2 OF 2 |
| APPROVED | MP | TITLE | SCALE |
| DE APPR. | MP | SHIM | NTS |
| DATE | 11.01.13 | COPYRIGHT © 2011 BY DART AEROSPACE LTD | |
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